

Work Order ID 50950

July 28, 2009 7:43:05 AM

Page 1

Item ID: D3656-3

Accept

Setup Start

Revision ID: B

Stop

Item Name: PANEL

Start Date: 7/30/09 Start Qty: 4.00

Cust Item ID:

Required Date: 8/04/09 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3656

Rev B

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks to fit frame size

BB 09/08/11 X4

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3656-3 and Folio FTA using tool
DT8987 □ Dwg. Rev. B □ Folio Rev. B A B

BB 09/08/11 X4

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Visually inspect for proper formation of each part

BB 09/08/17 X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 8/04/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

W/L 09/08/17

140

HAND FINISHING THERMOFORMING

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions as per dwg D3656

BB 09/08/17
xy

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Check dimensions to ensure conformity to drawing tolerances.

BB 09/08/17
(xy)

W/O:		WORK ORDER CHANGES					
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Accept

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Setup Start

Stop

Start Date: 7/30/09

Start Qty: 4.00

Required Date: 8/04/09

Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

=> 8/10/17

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

9/18/17 40 SY

09/08/18

mf 09-08-17

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 1

July 28, 2009 7:43:04 AM

Work Order ID: 50950



Parent Item: D3656-3RevB



Parent Item Name: PANEL

Start Date: 7/30/09

Required Date: 8/04/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,992.616	138.6400			



GE PLASTICS LEXAN SHEET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	1992.6166	
107574	16.62	
111973	797.33	
112176	1178.6666	

M 111973.

BB 09/08/17

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	50950
Description: PANEL FORWARD OVERHEAD		Part Number:	D3656-3
Inspection Dwg: D3656	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/08/17

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
60.25	REF	60.25	✓			
40.75	REF	40.75	✓			
.7	REF	.8	✓			
.045	Min	.045	✓			
.040	Min	.041	✓			
.050	Min	.074	✓			

Measured by: BB

Date: 09/08/17

Audited by: [Signature]

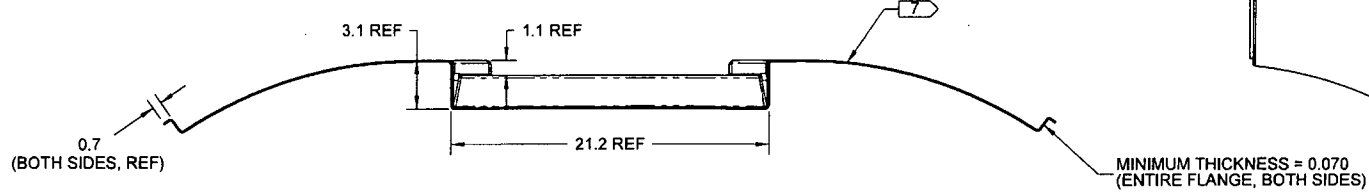
Date: 09/08/17

Prototype Approval: [Signature]

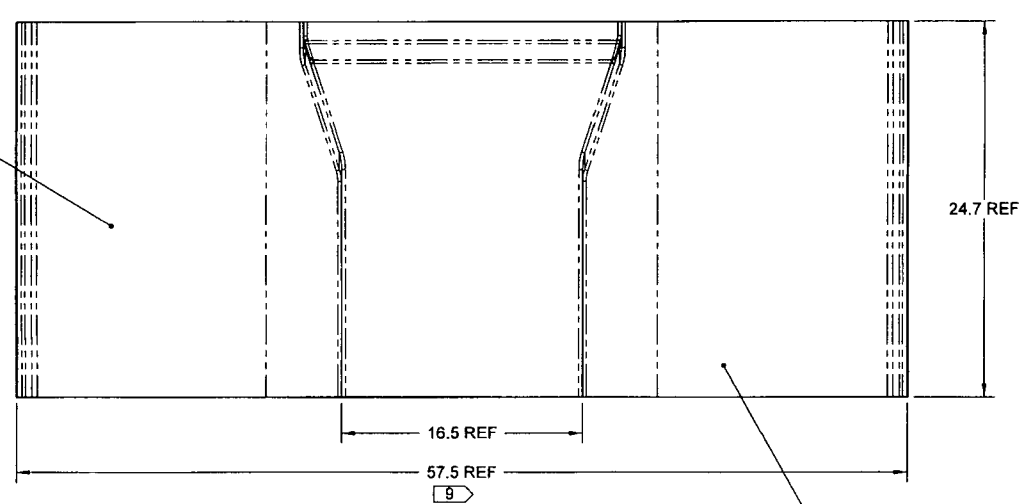
Date: a n

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

w/o 50950



TEXTURED SURFACE
ON THIS SIDE



D3656-1 PANEL

RELEASED
08-09-18

- NOTES:
- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
 - 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022 TRIM PER DT8986
 - 3) FINISH: NONE
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
 - 8) WEIGHT: 6.6 lbs
 - 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

B	REMOVE SKYLIGHT CUTOUTS, UPDATED NOTE 2 (A6-2); REASON: EASE OF MANUFACTURE AND CUSTOMER REQUEST	PH	08.09.18
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	LE	D3656	SHEET 1 OF 2
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	PANEL	NTS
DATE	08.09.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

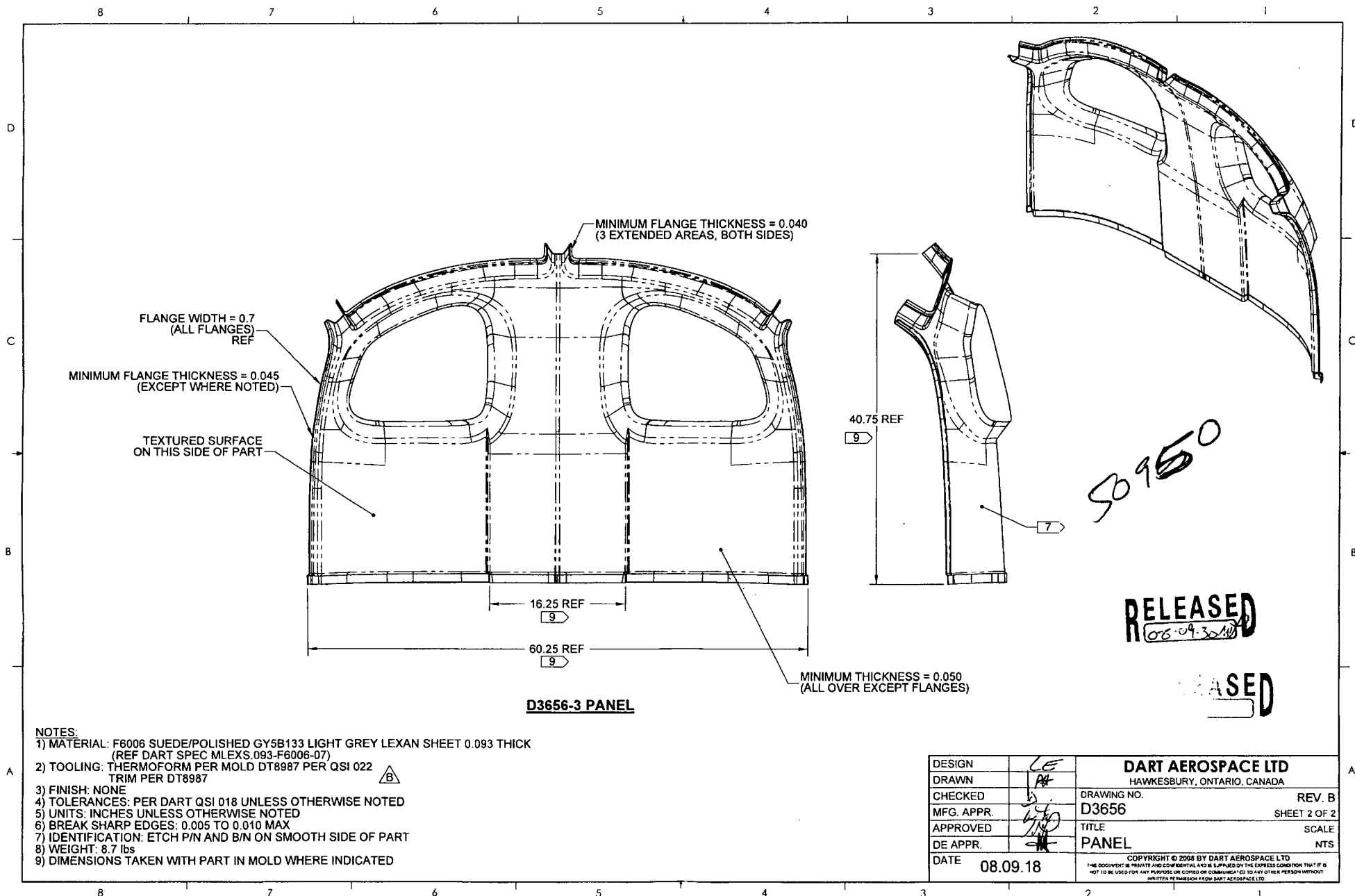
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